

SP/17

## Work Order ID 51125 - 2

August 4, 2009 11:05:21 AM



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg Assembly Hi

20

Start Date: 8/21/09 Start Qty: 40.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 40.00



Customer:

## Reference:

Approvals: Process Plan: *m f*

Date: 09-08-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3065	Rev B
-------	-------

100	
-----	--



Small Fab	
-----------	--

Small Fab	
-----------	--

<b>Memo</b>	0.00
-------------	------

Assemble as per Dwg D3065 and Identify as D3065-041	
---	--

110	
-----	--



QC	
----	--

Quality Control	
-----------------	--

QC5- Inspect part completeness to step on W/O	
---	--

0.00	
------	--

*→ Sol 10/18*

*Counted  
(+20) f*

120	
-----	--



Packaging	
-----------	--

Packaging	
-----------	--

Identify as per dwg & Stock Location: <i>WA</i>	
---	--

0.00	
------	--

*SAD 09-09-21*

*(200)*

*EF 09/09/18 (20)*

# Work Order ID 51125

August 4, 2009 11:05:21 AM



Page 2

Item ID: D3065-041

Accept



Setup Start



Revision ID: B

Item Name: Step Leg Assembly Hi

Stop



Start Date: 8/21/09 Start Qty: 40.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

QC



Memo

0.00

09/09/21 HJ

Quality Control

MF  
09-09-21

# Picklist Print

August 4, 2009 11:05:20 AM

Page 1

Work Order ID: 51125



13

Parent Item: D3065-041RevB



Parent Item Name: Step Leg Assembly Hi

Start Date: 8/21/09

Required Date: 9/04/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-1RevB



Manufactured

No

100

Each

70.0000

40.0000



Step Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

GA

-20

46333

-20

Main Warehouse

ST

90

46333

39

48113

51

D3065-3RevB



Manufactured

No

100

Each

90.0000

40.0000



Step Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

GA

60

48113

-20

50144

80

Main Warehouse

ST

30

48113

30

20

20

13

# Picklist Print

August 4, 2009 11:05:20 AM

Page 2

Work Order ID: 51125



Parent Item: D3065-041RevB



Parent Item Name: Step Leg Assembly Hi

Start Date: 8/21/09

Required Date: 9/04/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-5RevB



Manufactured

No

100

Each

0.0000

80.0000

Step Leg

EP 09/09/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-40

50145

-40

Main Warehouse

ST

40

50145

40

D3065-7RevB



Manufactured

No

100

Each

171.0000 40.0000



Step Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-20

45395

-20

Main Warehouse

ST

191

44395

34

45395

18

46333

49

48113

50

50146

40

# Picklist Print

August 4, 2009 11:05:20 AM

Page 3

Work Order ID: 51125



Parent Item: D3065-041RevB



Parent Item Name: Step Leg Assembly Hi

Start Date: 8/21/09

Required Date: 9/04/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-4

Purchased

No

100

Each

7,162.000 1,200.0000

Rivet, Universal Head



EP09/09/17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

7162

111359

2162

112314

5000

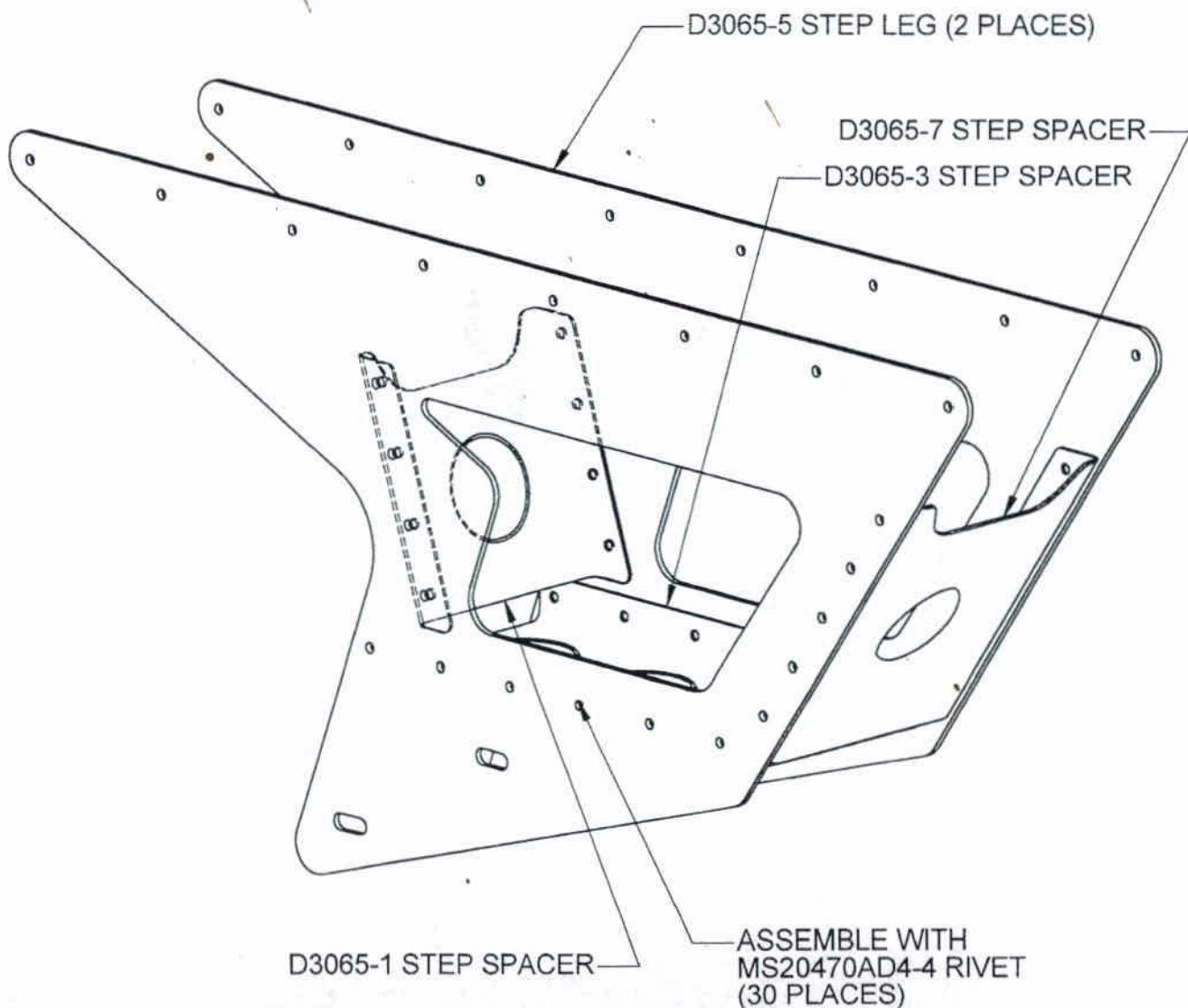
600

**DART**

DESIGN	CP	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	HH	DRAWING NO. D3065 REV. B SHEET 1 OF 5
DATE	06.05.23			TITLE STEP LEG ASSEMBLY SCALE 1:2
A	02.09.11			NEW ISSUE
B	06.05.23			ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

RELEASED

06.06.20 HH

# 51125  
MF  
09.08.04

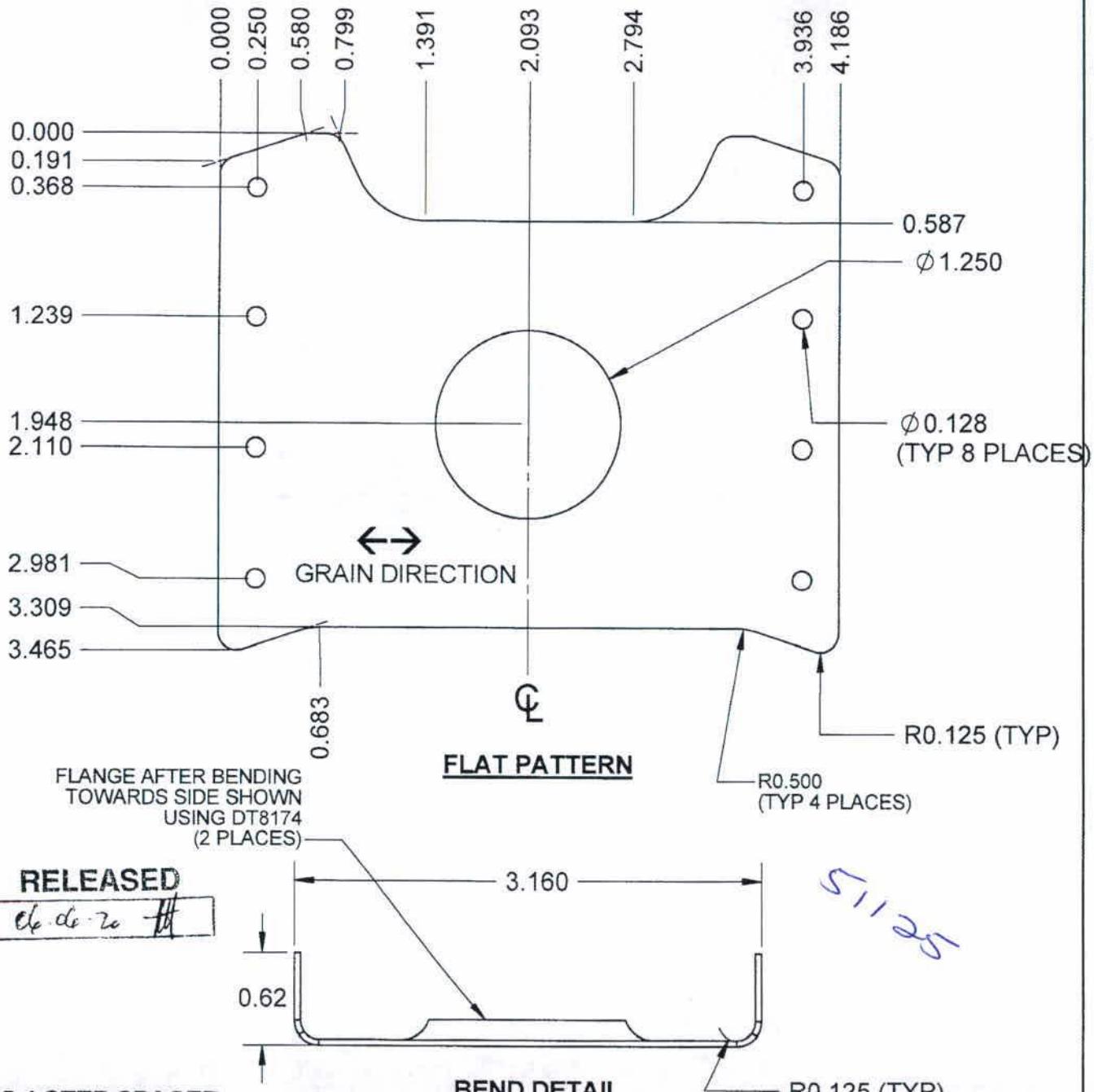
## D3065-041 STEP LEG ASSEMBLY

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CHECKED	APPROVED	DRAWING NO.	REV. B
PH		D3065	SHEET 2 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1



- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

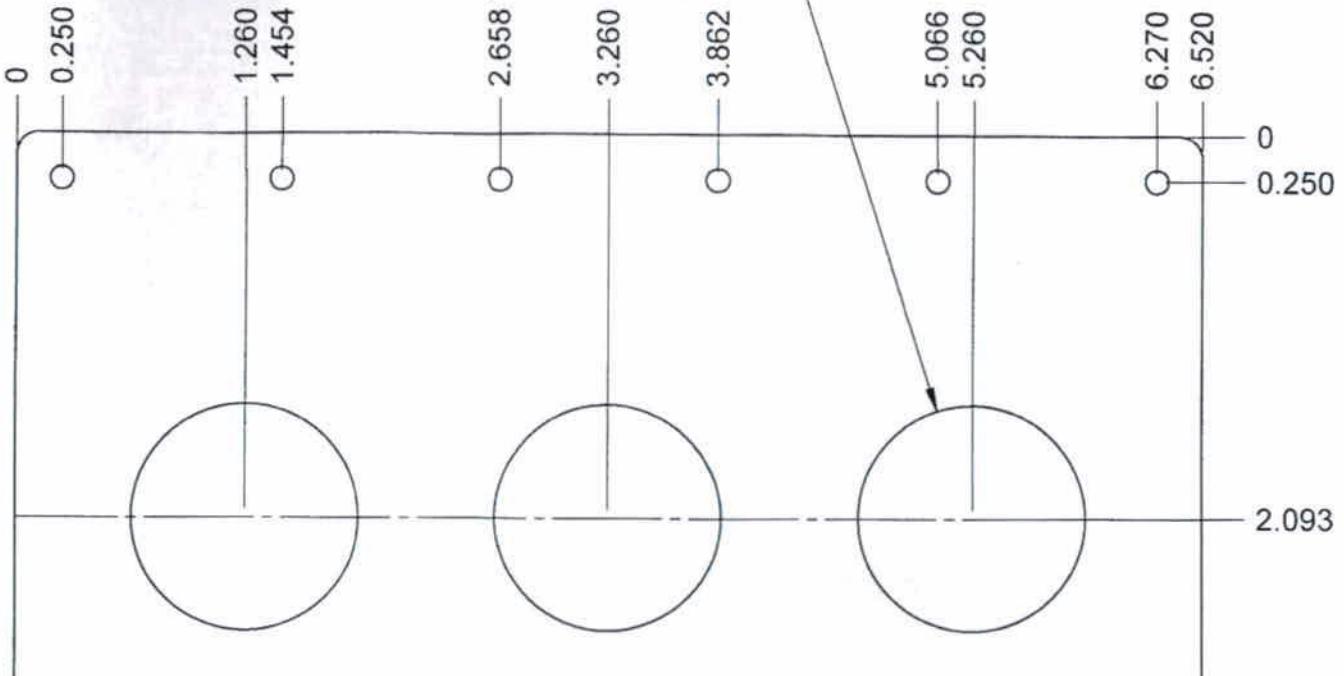
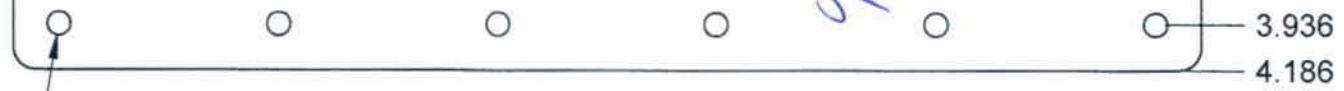
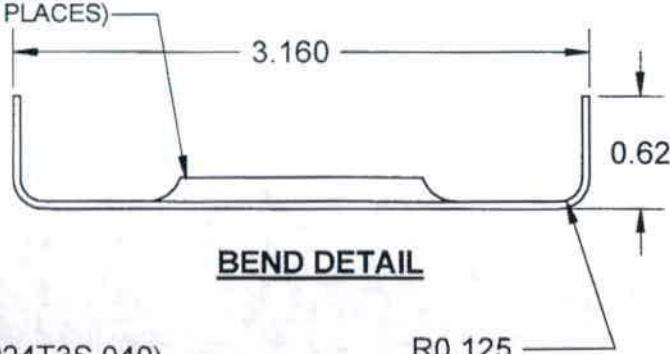
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P.H.		D3065	REV. B
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY

SHEET 3 OF 5

SCALE  
1:1 $\phi 1.250$  (TYP, 3 PLACES)FLAT PATTERNGRAIN DIRECTION  
*5/1251*FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)RELEASED  
*06.05.23***D3065-3 STEP SPACER**

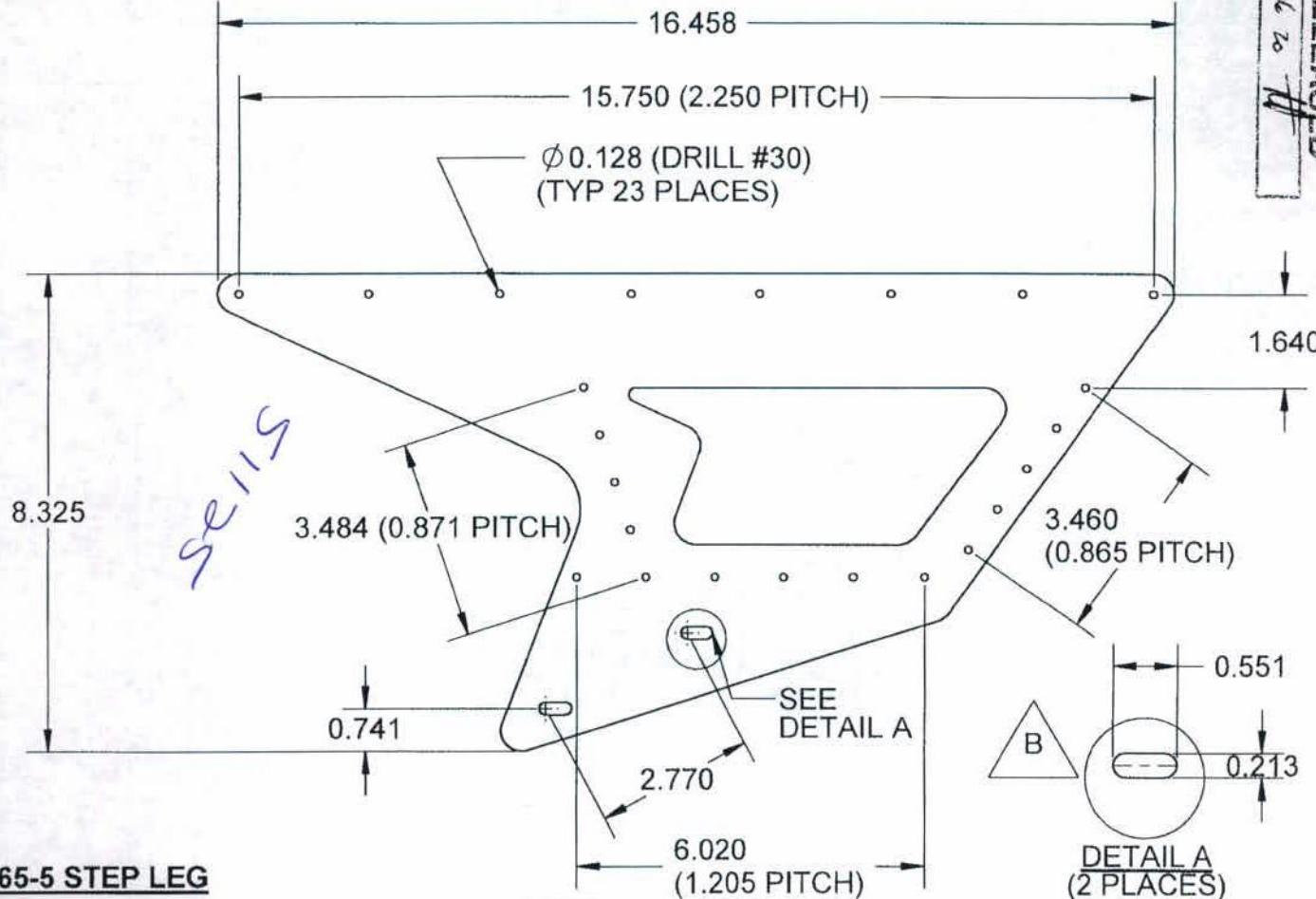
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

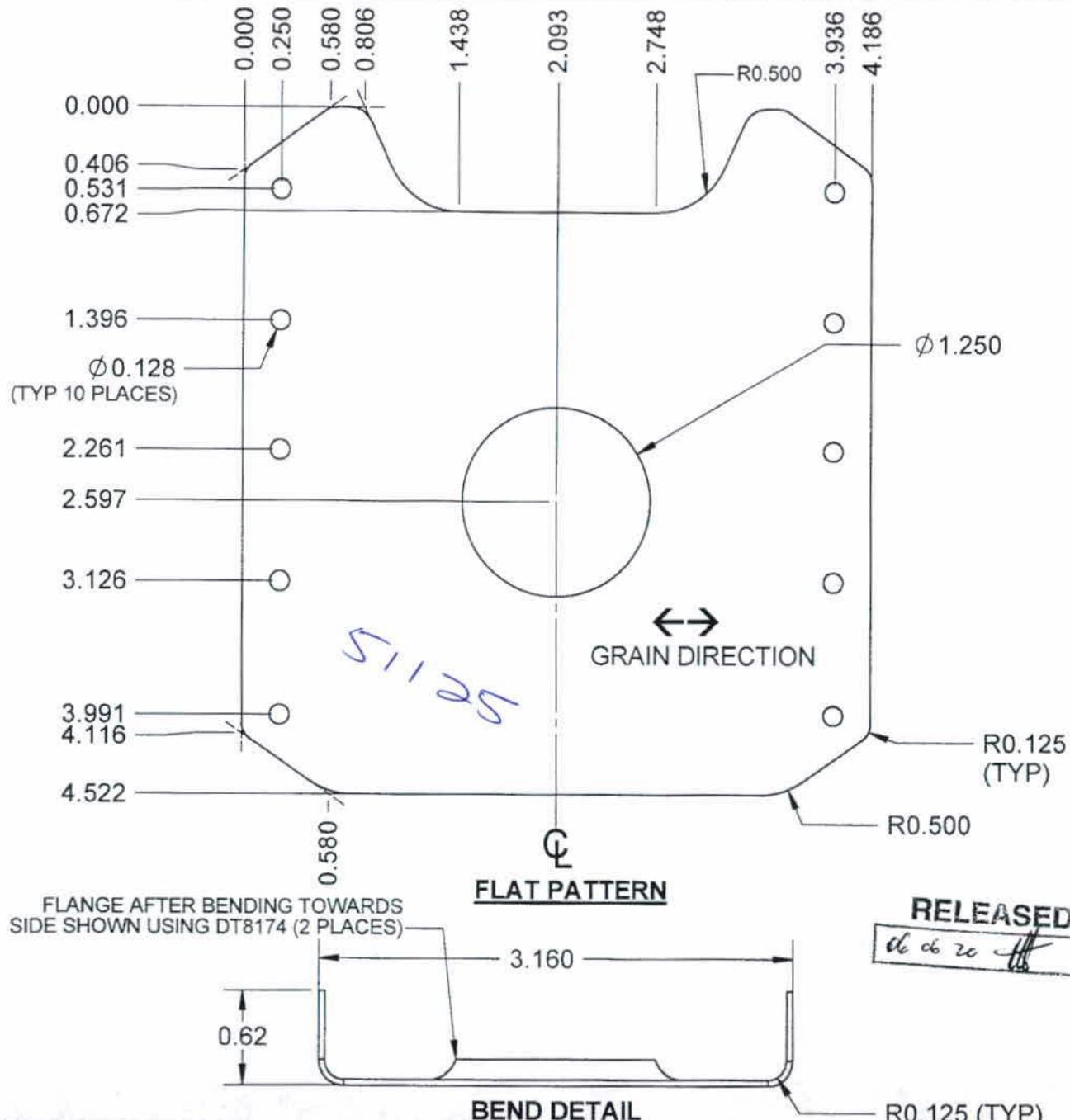
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5		SCALE 1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1	



## D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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